

# Work Order ID 61089

August 5, 2010 1:56:26 PM



Page 1

Item ID: D4048-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4048

A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.330" LONG

0.00

*cmf 20/08/14*

*4 0*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA897

DWG REV: *A*

FOLIO REV: *4A*

DEBURR

0.00

*cmf 16/08/16*

*4 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

\_\_\_\_\_

Page 2

**Abstract**

**00000000000000000000000000000000**

**Stop**

**RESEARCH DESIGN**

**Cust Item ID:**

**Abstract**

**Customer:**

Run Start

**Acknowledgments**

**Stop**

[illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

2010/08/16

[REDACTED]

QC

## Memo

0.00

## Quality Control

0.00

LA 10/08/14



QC

## Memo

0.00

### Quality Control

0.00

**Abstract**

HandFinish

## Memo

0.00

### Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61089**

Page 4

August 5, 2010 1:56:27 PM

Item ID: D4048-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19

MF  
10-8-18

# Picklist Print

August 5, 2010 1:56:25 PM

Page 1

Work Order ID: 61089

Parent Item: D4048-6

Parent Item Name: Mounting Lug



Start Date: 8/05/10

Required Date: 8/13/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC IPP  
Rev:B as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased	No			100	f	11.2643	0.44441	1.8712			
6061T6 Bar 1.500 x 4.00													

Location

MAT09

113797

Loc Qty

11.2643

11.2643

Loc Code

1.8712 *ml*  
10/08/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

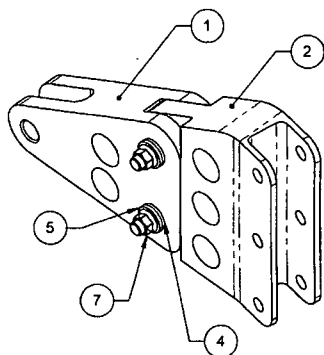
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 61089
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D4048-6
<b>Inspection Dwg:</b> D4048 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

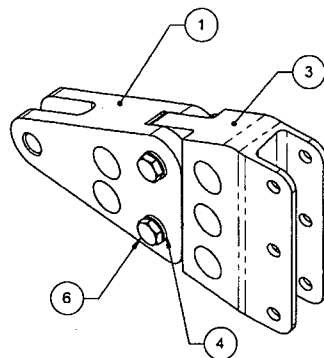
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.11	+/-0.030	5.105	—		H-G	31006
1.38	+/-0.030	1.375	—		Vern	ML-7
1.00	+/-0.030	1.003	—		"	"
0.770	+/-0.010	.769	—		"	"
0.415	+0.015/-0.000	.417	—		"	"
0.293	+/-0.010	.288	—		"	"
0.115	+/-0.010	.116	—		"	"
3.75	+/-0.030	3.750	—		"	"
3.000	+/-0.010	3.000	—		"	"
1.500	+/-0.010	1.500	—		"	"
0.38	+/-0.030	.375	—		"	"
0.375	+/-0.010	.375	—		"	"
Ø0.257	+0.006/-0.001	Ø.259	—		"	"
0.400	+/-0.010	.397	—		"	"
0.200	+/-0.010	.202	—		Micro.	ML-1
2.34	+/-0.030	2.338	—		Vern	ML-7
1.63	+/-0.030	1.630	—		"	"
2.27	+/-0.030	2.270	—		"	"
Ø0.375	+0.006/-0.001	Ø.378	—		"	"
0.435 x 45°	+/-0.010 x +/-0.5°	.432x45°	—		"	"

<b>Measured by:</b> <i>aml</i>	<b>Audited by:</b> B.A	<b>Preliminary Approval:</b>
<b>Date:</b> 10/08/16	<b>Date:</b> 10/08/16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	<i>[Signature]</i>



**D4048-041 MOUNTING LUG ASSY (SHOWN)**



**D4048-042 MOUNTING LUG ASSY (SHOWN)**

**NOTES:**

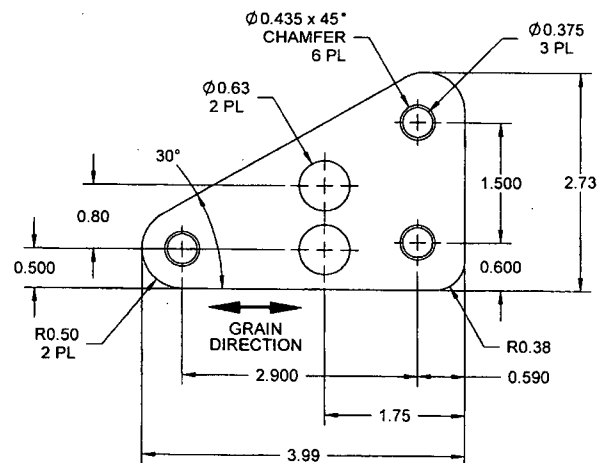
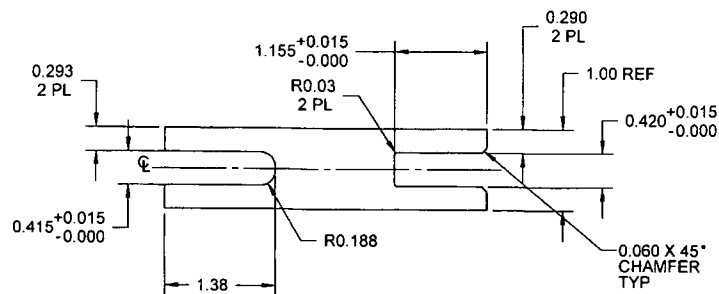
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4048-041/-042: 1.16 lbs
- 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

ITEM	QTY -041	QTY -042	P/N	Description
	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

*W/O 61089*

**RELEASED**  
2010-02-16

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>GP</i>	D4048	SHEET 1 OF 9
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	MOUNTING LUG ASSY	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



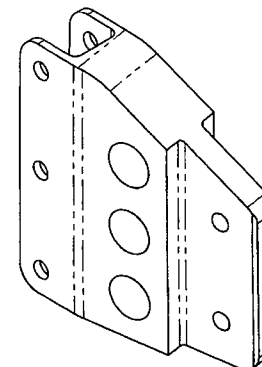
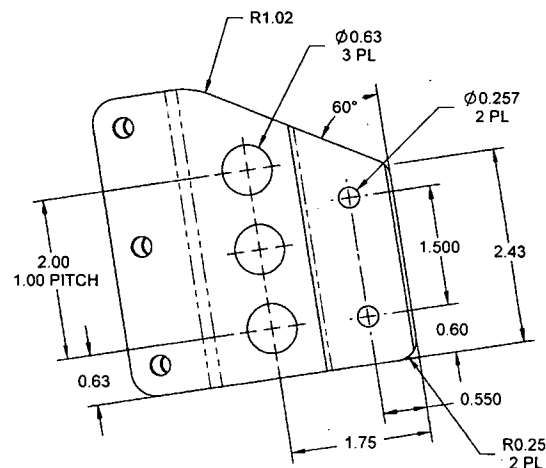
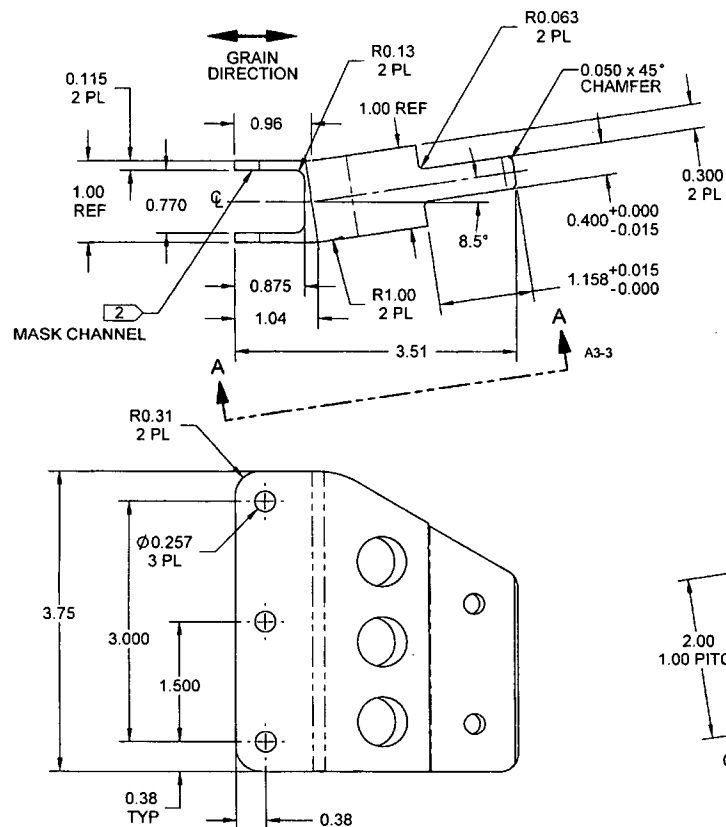
# **D4048-1 MOUNTING LUG**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø0.315 HOLES PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

**RELEASED**  
R 2010-02-16

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>g</i>	<b>D4048</b>	SHEET 2 OF 9
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>A</i>	<b>MOUNTING LUG ASSY</b>	NT
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*W06089*

VIEW A-A C5-3

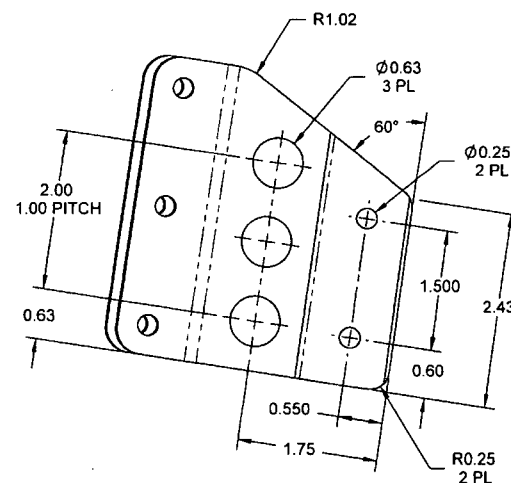
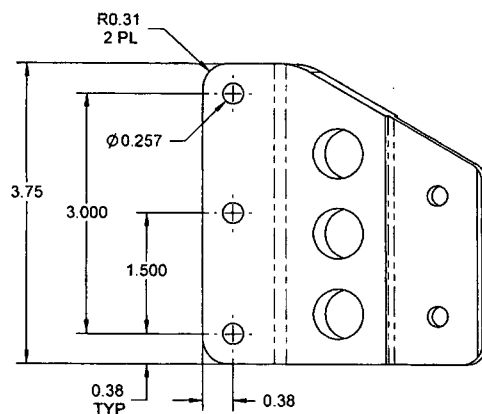
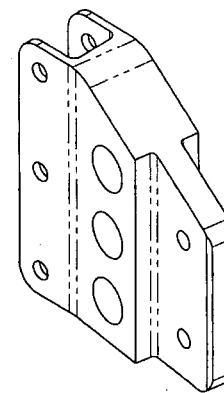
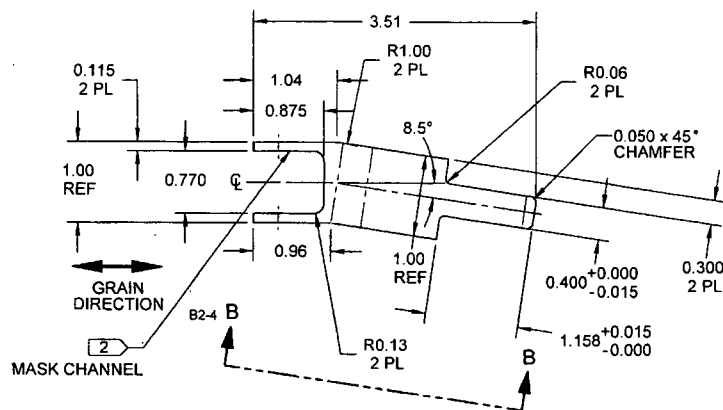
# D4048-3 MOUNTING LUG

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-3)  
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

**RELEASED**  
2010-02-16  
*MP*

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>g</i>	<b>D4048</b>	SHEET 3 OF 9
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	<b>MOUNTING LUG ASSY</b>	NTS
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2010-02-16  
MD

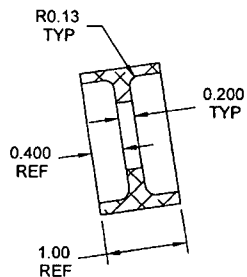
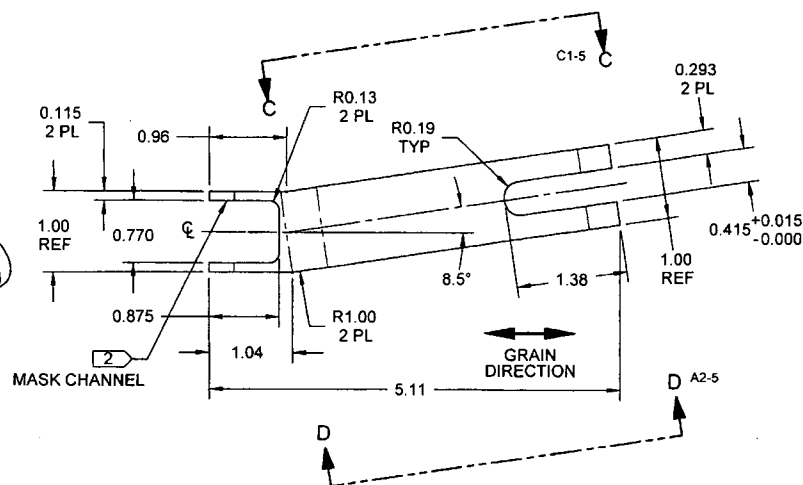
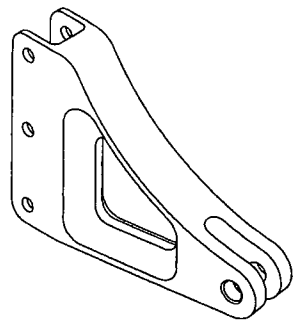
#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-4)  
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

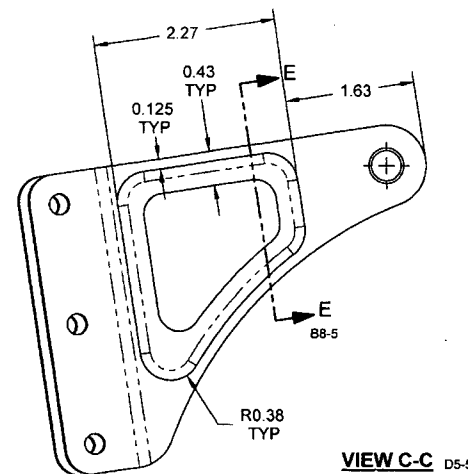
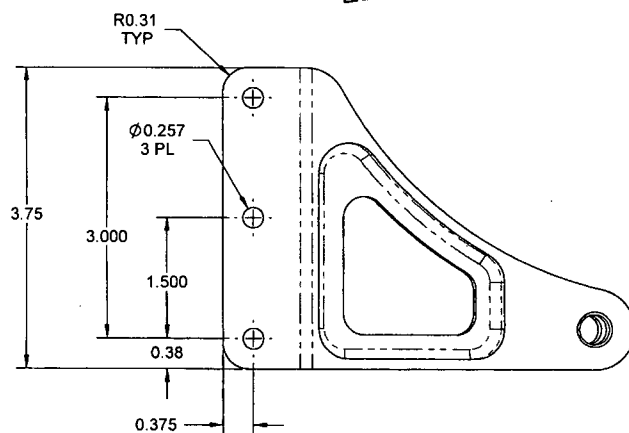
#### D4048-4 MOUNTING LUG

VIEW B-B C6-4

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4048	SHEET 4 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MOUNTING LUG ASSY	NTS
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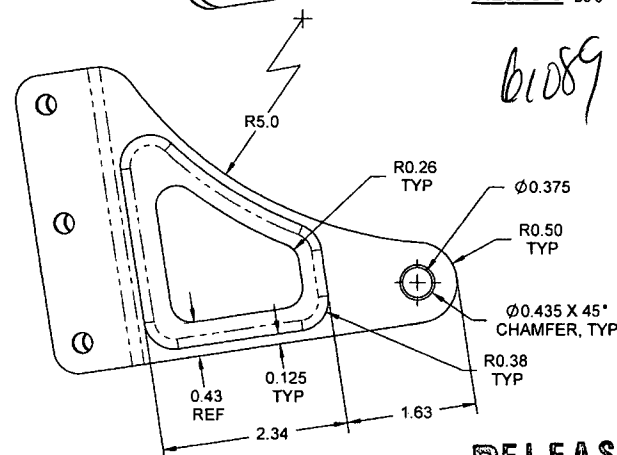


# **SECTION E-E** C2-5



# **VIEW C-C** D5-5

*61089*



# **VIEW D-D** C4-5

**RELEASED**  
R 2010-02-16  
*WPD*

## **NOTES:**

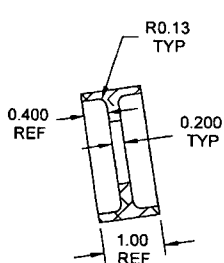
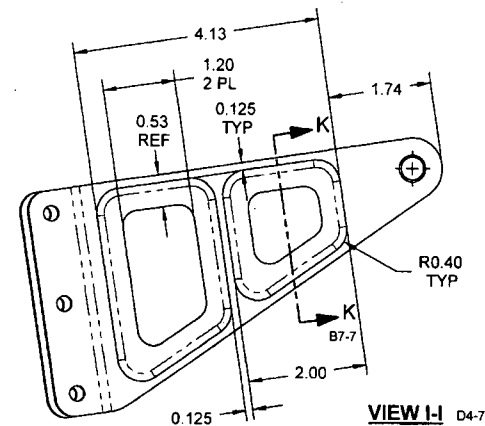
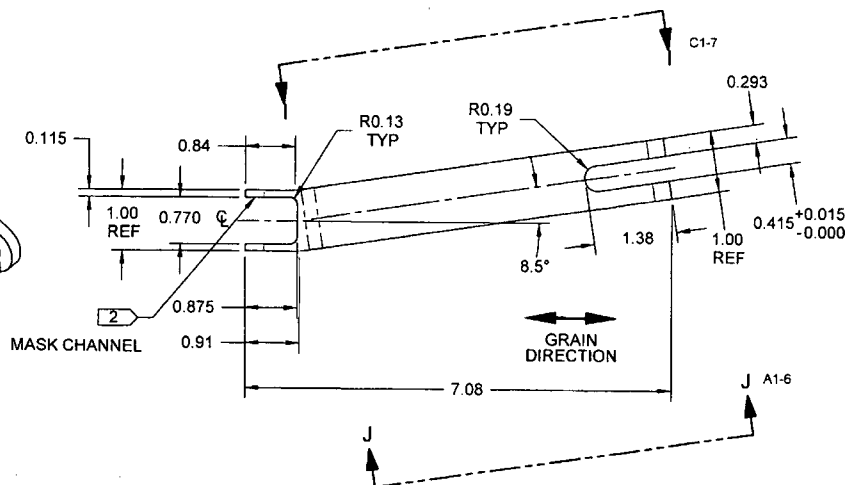
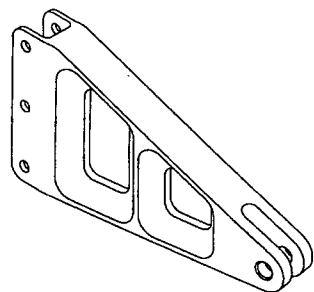
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK  $\phi 0.257$  HOLES AND INDICATED CHANNEL (ZN C7-5)  
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.44 lbs

## **D4048-5 MOUNTING LUG**

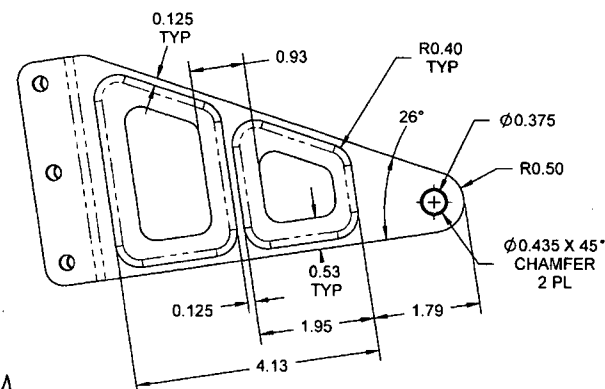
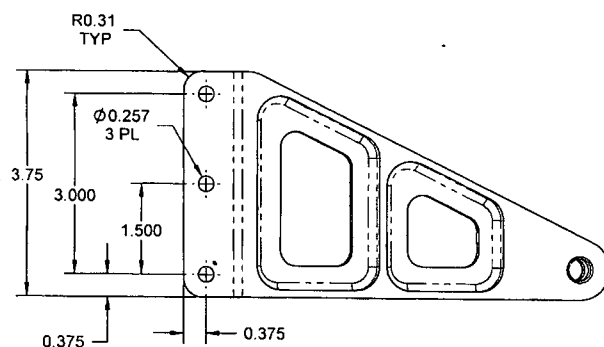
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	GP	<b>D4048</b>	SHEET 5 OF 9
APPROVED	WPD	TITLE	SCALE
DE APPR.	WPD	<b>MOUNTING LUG ASSY</b>	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>GP</i>	<b>D4048</b>	SHEET 6 OF 5
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>A</i>	<b>MOUNTING LUG ASSY</b>	NTS
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**SECTION K-K** C2-7



**VIEW J-J** C4-7

**RELEASED**  
2010-02-16

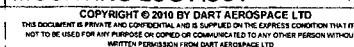
**NOTES:**

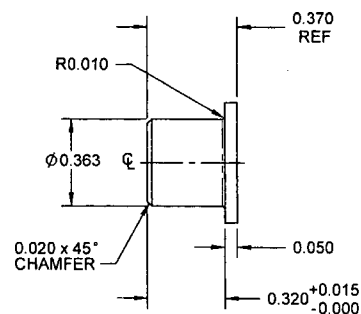
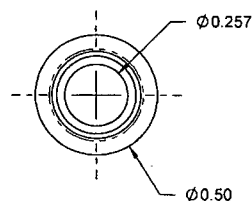
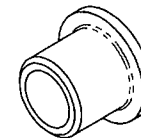
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-7)  
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-7" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.62 lbs

**D4048-7 MOUNTING LUG**

*WLO 6/08/09*

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4048</b>	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MOUNTING LUG ASSY</b>	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





# **D4048-9 BUSHING**

61089

**RELEASED**  
2010-02-16

## **NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR  
REF DART SPEC. M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	<b>D4048</b>	SHEET 9 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>MOUNTING LUG ASSY</b>	NTS
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